

Work Order ID 55936

February 5, 2010 11:15:25 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4000-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Grommet

Start Date: 2/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*14*

Date: 10-2-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4000	<del>A PRELIM</del>

Rev. A *CE*

100		0.00							
	Hardinge								
	Hardinge CNC Lathe Small								

Memo

TURN AS PER DWG AND FOLIO FA910  
DWG REV: *A Prelim*  
FOLIO REV: *SD 10/02/05*

*4* *2*

110		0.00							
	QC								
	Quality Control								

QC2- Inspect parts off machine FAI/FAIB

Memo

*SD 10/02/05*

*4* *2*

120		0.00							
	QC								
	Quality Control								

QC8- Inspect parts - second check

Memo

no changes from ~~FA~~ Prelim. Day to Rev A  
Not inspected to A ~~FA~~ Release Day

*SD 10/02/05*  
*SD 10/02/05*

*4* *2*

*PRELIM*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55936

February 5, 2010 11:15:25 AM



Page 2

Item ID: D4000-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Grommet

Start Date: 2/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: *per run shelves*

0.00



Packaging

Memo

0.00

Packaging

*EC 10-04-22*

*(4)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Ates.*

*10-2-19 (4)*

POSITIVE RECALL

EFFECTIVE *10-02-15* AUTH *[Signature]*

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

*QW1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

February 5, 2010 11:15:29 AM

Work Order ID: 55936



Parent Item: D4000-9



Parent Item Name: Grommet

Start Date: 2/05/10

Required Date: 2/12/10

Comments: IPP REV:A NEW ISSUE 10-02-05 JLM VERIFIED BY:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MDELNRINR1.2500

Purchased

No

100

f

4.3240

0.2105



DELIN ROUND BAR 1.25

1.500"  
JLM 10-02-05

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

4.324

~~1.10250~~

4.324

M110115

18 RA SA 10/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

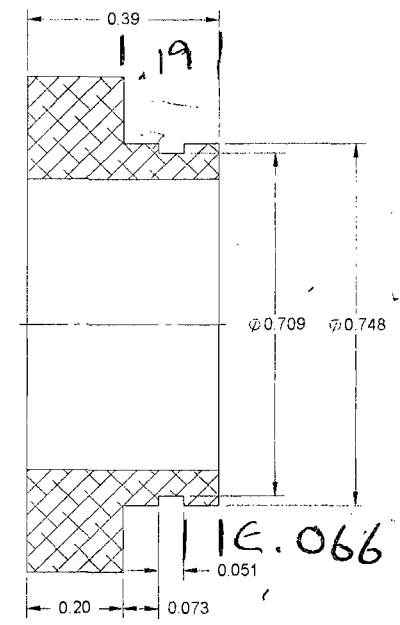
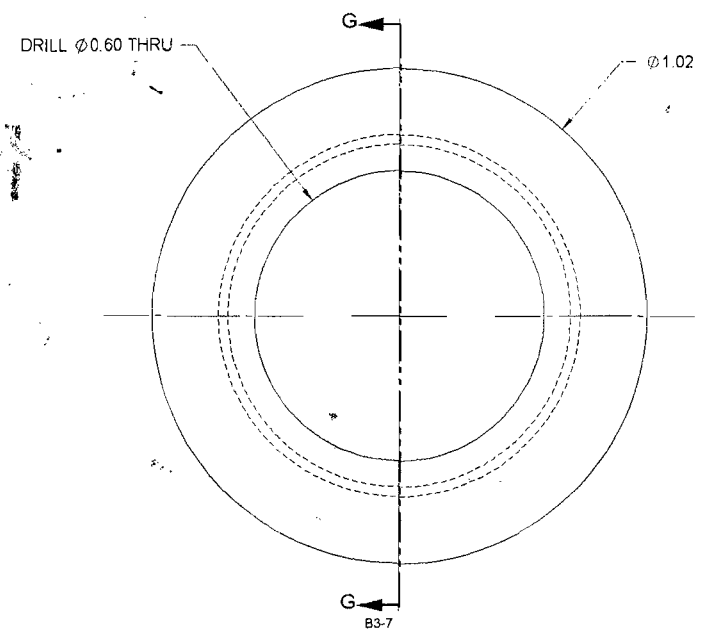
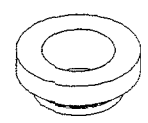
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

4x

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55936  
BH 10-2-05



**SECTION G-G**  
B6-7

**D4000-9 GROMMET**

1.651  
0.073  
1.24  
1/4 910

- NOTES:
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL,  $\phi$  1.000 ROUND BAR  
REF DART SPEC M-DELRIN-R1.000
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D4000	SHEET 7 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		FITTING	NTS
DE APPR.			
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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

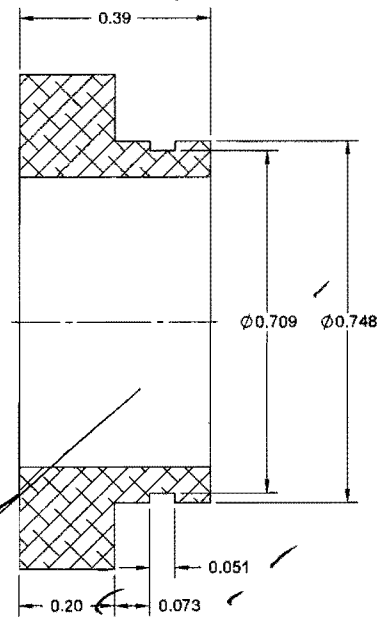
DRILL  $\phi 0.60$  THRU

$\phi 1.02$

G

G

B3-7



**D4000-9 GROMMET**

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL,  $\phi 1.000$  ROUND BAR  
REF DART SPEC M-DELRIN-R1.000
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- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4000</b>	SHEET 7 OF 8
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DART AEROSPACE  
PART NUMBER

D4000-9

JOHN CAMERON AVIATION  
PART NUMBER

JCA-M47-1-11

DRILL Ø0.60 THRU

Ø1.02

G

G

83-7

0.39

Ø0.709

Ø0.748

0.13 x 45° CHAMFER

0.051

0.20 0.073

SECTION G-G

86-7

**D4000-9 GROMMET**

**RELEASED**  
2010-05-05

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.000 ROUND BAR  
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